

Ship out 15

Split
80 07/10/14

Date: Friday, 9/21/2007 1:19:01 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : UPPER AND LOWER PLATE
Job Number : 34824	
Estimate Number : 12838	
P.O. Number : <u>N/A</u>	Part Number : D3524041
This Issue : 9/21/2007 S.O. No. : <u>N/A</u>	Drawing Number : <u>UNDER REVIEW D3524</u>
Prsht Rev. : NC	Project Number : N/A
First Issue : 9/21/2007 Type : MACHINED PARTS	Drawing Revision : <u>N/A Δ</u>
Previous Run : 33303	Material : <u>NA</u>
Written By : _____	Due Date : 10/12/2007
Checked & Approved By : <u>[Signature]</u>	Qty: <u>20</u> Um: <u>20</u> Each
Comment : Est Rev: A New Issue 07-04-18 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0375X03000	6061T6 BAR .375 X 3.00
-----	--------------------	------------------------



Comment: Qty.: 0.3236 f(s)/Unit Total: 1.6181 f(s)
6061-T6 Bar .375" X 3.00"
batch: 1105225

NO BATCH# IN COMPUTER

JIP 07/10/05

20

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blank 3.700 " long

JIP 07/10/05

20

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA700 Rev: AA & Dwg D3524Rev: A

2-Deburr per dwg D3443

JIP 07/10/09

20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JIP 07/10/09

20

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.L 07/10/11

20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:19:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UPPER AND LOWER PLATE

Job Number: 34824

Part Number: D3524041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
C'SINK AS PER DWG D3524

mf

07-10-11

(20)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5

07/10/11

counter

(720)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

41

07-10-11

(20)

9.0

MS21075L06

ANCHOR NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

ANCHOR NUT

batch: m101507

x68mx

m105978

x12mx

mf

10.0

MS20426AD34

RIVET



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

RIVET

batch: m102404

x

160mx

mf

07-10-23

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
RIVET NUT PLATESAS PER DWG D3524

mf

07-10-23

(3)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5

07/10/23

(43)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/10/23

x3

54

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/11	11	Split w/o			SB	07/10/11	3		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:19:02 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UPPER AND LOWER PLATE

Job Number: 34824

Part Number: D3524041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



20

Comment: FINAL INSPECTION/W/O RELEASE

D 21/10/07

Job Completion



U 0710.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

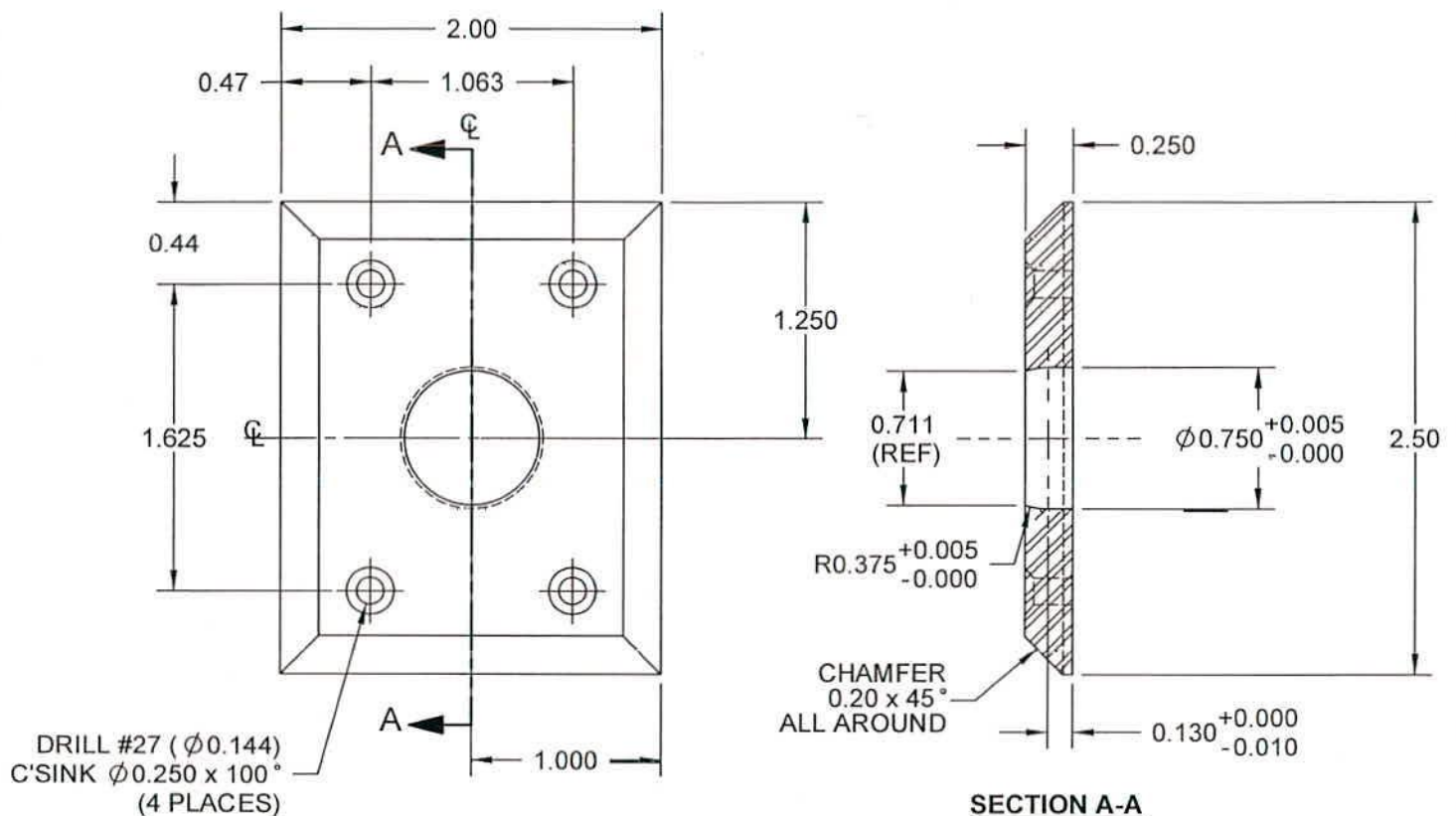
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D3524	REV. A SHEET 1 OF 3
DATE 07.07.24		TITLE UPPER AND LOWER PLATE	SCALE 1:1
REV A	DATE 07.07.24	DESCRIPTION NEW ISSUE	

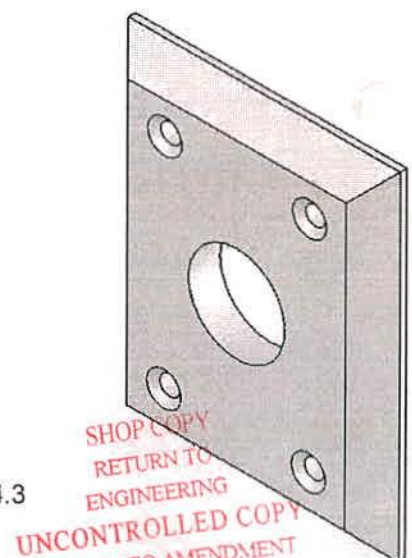


D3524-1 LOWER PLATE

RELEASED
07.08.03

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART SYMMETRIC ABOUT ϕ



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WITHOUT NOTICE
WORK ORDER
NO. _____

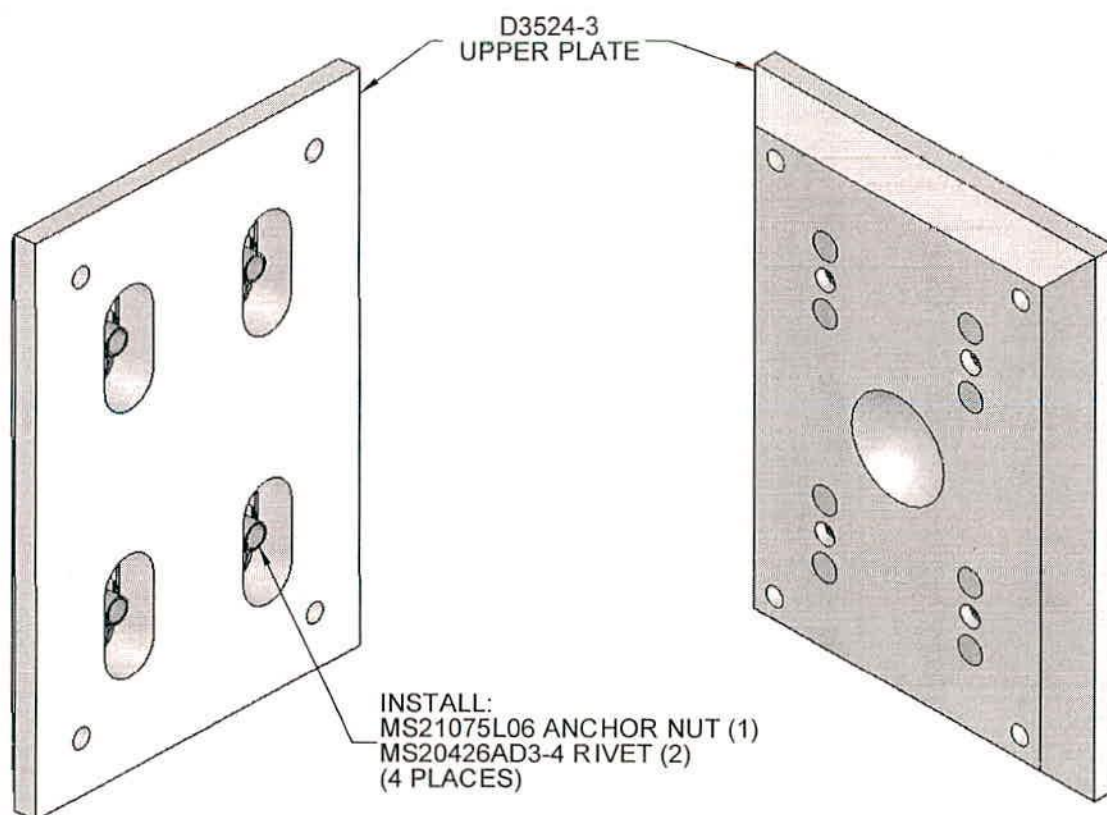
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DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3524	REV. A SHEET 2 OF 3
DATE 07.07.24		TITLE UPPER AND LOWER PLATE	SCALE 1:1



D3524-041 UPPER PLATE ASSEMBLY

RELEASED
07.08.03 #

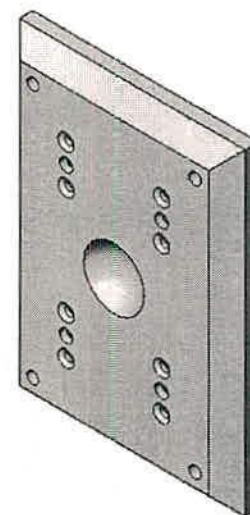
PARTS LIST:

QTY	P/N	DESCRIPTION
X	D3524-041	UPPER PLATE ASSEMBLY
1	D3524-3	UPPER PLATE
4	MS21075L06	ANCHOR NUT
8	MS20426AD3-4	RIVET

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NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER
QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR
QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART SYMMETRIC ABOUT C

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07-08 SOURCE TO AMENDMENT
OTHER NOTICE

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WORK ORDER

DART AEROSPACE LTD	Work Order: 34824
Description: UPPER PLATE	Part Number: D3524-3
Inspection Dwg: D3524 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	±.030	2.500	—			
1.25	±.030	1.250	—			
1.75	±.030	1.750	—			
3.50	±.030	3.502	—			
0.35	±.030	0.350	—			
1.800	±.005	1.800	—			
0.35	±.030	0.350	—			
2.800	±.005	2.800	—			
0.20X45°	±.030	0.187X45°	—			
0.345	±.010	0.347	—			
0.210	±.005	0.210	—			
R0.375	±.005 ±.000	R0.375	—			
0.075	±.010	0.077	—			
0.375	±.010	0.376	—			
Ø0.144	±.004 ±.001	Ø0.145	—			
0.218	±.005	0.218	—			
Ø0.129	±.004 ±.001	Ø0.130	—			
1.063	±.005	1.063	—			
0.72	±.030	0.719	—			
0.94	±.030	0.940	—			
1.625	±.005	1.625	—			
Ø0.098	±.004 ±.001	Ø0.099	—			

Measured by: <i>me</i>	Audited by: <i>JF</i>	Prototype Approval: <i>alr</i>
Date: 07/10/08	Date: 07/10/08	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

